Work	0	rder	ID	74733
TTUIN	$\mathbf{v}$	1401		171133

Wednesday, October 05, 2011 2:35:12 PM



Page 1

Item ID:

D3506-1

Accept



Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Item Name: Doubler

**Required Date:** 10/14/2011

10/5/2011

**Start Qty: 12.00** Req'd Qty: 12.00



Cust Item ID:

**Customer:** 

Reference:

Approvals:

Process Plan:

Date: **//-/0-5** Tooling:

Date:

Run

Start

Stop



**Revision Nbr** 

Date:

SPC (Y/N):

Date:

Tool # Plan

Accept

Reject

Insp.

Sequence ID/ **Work Center ID Draw Nbr** 

Operation Description

Set Up/ **Run Hours**  Tool ID

Code

Qty

Reject **Qty** 

Number Stamp

D3506

Rev A

100

Waterjet

FLOW CNC Waterjet 6001.100

FLOW WATER JET

Memo

1-Cut as per Dwg D3506 Deburr if necessary

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00



Quality Control

Memo

0.00

B11-10-37

120

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio FA640 and Dwg D3506



Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:	i	PAR #:	Fault Car	degory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
	R	esolution:	Disposit	ion:	QA: N/C CI	osed:		Date: _	
NCR:	***	V	VORK OR	DER NON-CONFORMA	NCE (NCR	1)			
DATE	CTED	Description of NC	Corrective Action Section B			Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		tion C	Chief Eng	QC Inspector
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### Work Order ID 74733

Page 2

Item ID:

Wednesday, October 05, 2011 2:35:12 PM D3506-1

Accept

Setup Start

Stop

Stop



**Revision ID:** 

Item Name: Doubler

**Required Date: 10/14/2011** 

10/5/2011

**Start Qty: 12.00** Req'd Qty: 12.00

**Cust Item ID:** 

**Customer:** 

Reference:

**Start Date:** 

**Approvals:** 

Process Plan:

Date:

Tooling:

Date:

Date:

Start Run

Date:

SPC (Y/N):

Tool ID

Tool # Plan

Code

Reject Accept Qty Qty

Reject Insp. Number Stamp

Sequence ID/ Work Center ID

130

Quality Control

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/ **Run Hours** 

0.00

21

140

QC8- Inspect parts - second check

Memo

Memo

0.00

0.00

Quality Control

150

Small Fab Small Fab

Small Fab

Memo

0.00

0.00

C'sink as per Dwg D3506(On Flat side)

Dart Aerospace L	td
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										· · · · · ·	
W/O:			WO	RK ORDER CHAN	GES		. ,	. •			
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву			Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No		PAR #:	Fault Cate	gory:	NCR: Ye	es No	DQA	<b>\:</b>	_ Date: _		
			Disposition: QA: N/C Closed: Date								
NCR:			WORK ORD	ER NON-CONFORM	JANCE (N	CR)		-			
DATE	STEP	Description of NC			ection B		Verific	ation	Approval	Approval	
Part No: _	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section	on 'C	Chief Eng	QC Inspector	
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#### Work Order ID 74733

Wednesday, October 05, 2011 2:35:12 PM



Page 3

Item ID:

D3506-1

Accept

Setup Start

Stop

Start

Stop



**Revision ID:** 

**Start Date:** 

Item Name: Doubler

10/5/2011

**Start Qty: 12.00** 

**Required Date: 10/14/2011** Req'd Qty: 12.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Set Up/

Run Hours

Date:

Date:

Run



Date: SPC (Y/N):

Tool # Plan

Accept Qty

Reject

Reject Insp. Number

Work Center ID

160

Sequence ID/

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Memo

Memo

Tool ID

Code

Qty

Stamp

170

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

B 11-11-8.

180

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

Dart	Aeros	pace	Ltd
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	•								•
W/O:		PH 4	RK ORDER CHANG	ES					
DATE	DATE STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: PAR #: _			Fault Categ	jory:	No <b>DQA: Date:</b>				
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NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)			<u> </u>
DATE	STEP	Description of NC		Corrective Action Secti		Verific	ation	Approval	Approval
DATE	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on °C	Chief Eng	QC Inspector
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### Work Order ID 74733

Wednesday, October 05, 2011 2:35:12 PM



Page 4

Item ID:

D3506-1

Accept

Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Item Name:

**Required Date: 10/14/2011** 

Doubler

10/5/2011

**Start Qty: 12.00** 

Req'd Qty: 12.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

QC: \_\_\_

Date: \_\_\_\_\_

Tooling:

Date:

Start

Stop



Date:\_\_\_\_\_

SPC (Y/N):

Set Up/

**Run Hours** 

Tool ID

Tool # Plan

Accept

Reject

Insp. Reject

Work Center ID

190

Sequence ID/

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

0.00

0.00

Date:

Code Qty Qty

Run

Number Stamp

200

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

Dart Aerospace Lt	d
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W/O:	<u>.</u>		WO	RK ORDER CHANG	GES				
DATE	STEP	PRO		Control of the Contro	Ву	Date	Qty	Approval Chief Eng / Prod Mar	Approval QC Inspector
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Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
			PROCEDURE CHANGE  By Date Qty Chief Eng / Prod Mgr  R #: Fault Category: NCR: Yes No DQA: Date: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR)						
NCR:		1	WORK ORDI	ER NON-CONFORM	ANCE (NCR	()			
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DATE	SIEF	STEP Description of NC Section A							Approval QC Inspector
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## **Picklist Print**

Wednesday, October 05, 2011 2:35:17 PM

Work Order ID: 74733

Parent Item:

D3506-1

Parent Item Name: Doubler



Start Date: 10/5/2011

**Required Date: 10/14/2011** 

Page 1

**Start Qty: 12.00** 

Required Qty: 12.00

**Comments:** 

IPP Rev:A New Issue 06-05-31 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.100		Purchased	No			110	sf	108.4000	0.0078	0.098526	`-	<u> </u>	•
6061-T6 .100 Sheet		-		Location	1	Loc	Otv	Loc Code		(1)	11-10 -9		

<b>Location</b>	Loc Qty	Loc Code		
MAT021	108.4			
102201	1			(52)
118072	22.9			
118523	84.5		118523	

# **Dart Aerospace Ltd**

N/O:			W	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date Qty	Qty Approval Chief Eng / Prod Mgr		
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQA:	Date: _		
Resolution:			Disposition	on:	QA: N/C Clo	sed:	Date: _	·	
NCR:		1	WORK ORE	DER NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC		Corrective Action Section		Verification		Approval	
	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
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					**				

DART AEROSPACE LTD	Work Order:	74953
		t ·
Description: Doubler	Part Number:	D3506-1
Inspection Dwg: D3506 Rev: A		Page 1 of 1

	FIRS <sup>-</sup>	T ARTICLE INSF	PECTION	CHECKL	_IST	
	X	First Article	F	Prototyp	е	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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Ø0.404	+0.006/-0.001	1 405	~		ν	
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1.500	+/-0.010	1.504	×		V	
0.375	+/-0.010	,374	>		V	
0.750	+/-0.010	749	×		V	
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Date:	11-10-51	Date: //	11/05		Dat	

F	lev	Date	Change	Revised by	Approved
	Α	07.03.09	New Issue	KJ/JLM	B

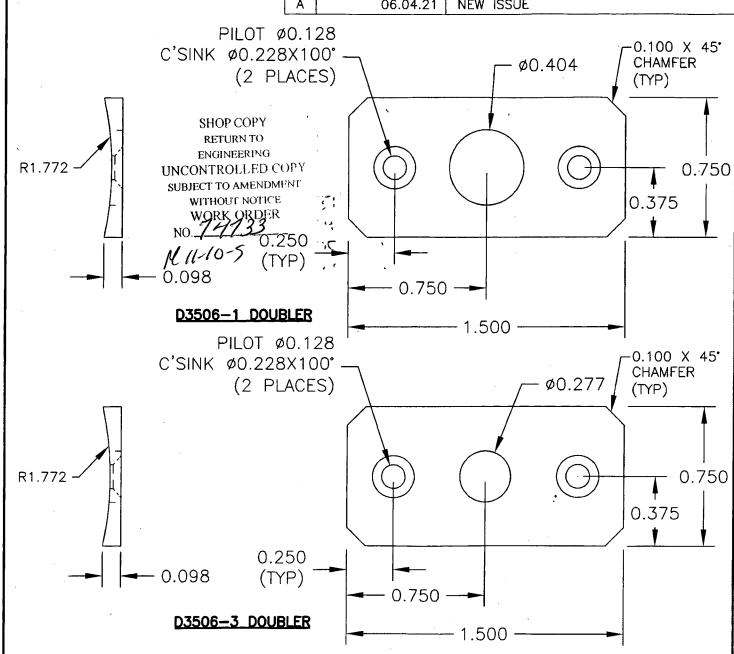
# **Dart Aerospace Ltd**

W/O:	•		W	ORK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes	No <b>DQ</b>	A:	Date: _	
	R	esolution:	Dispositi	on:	_ QA: N/C	Closed:		Date: _	
NCR:			WORK ORE	DER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sect  Action Description  Chief Eng	ion B Sign	& Sect	cation ion C	Approval Chief Eng	Approval QC Inspector
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CHEC	KED #	APPROVED	DRAWING NO. D3506	REV. SHEET 1 OF	
DATE			TITLE	SCAL	.E
06.0	)4.21	=	DOUBLER	2	:1
		06.04.21	NEW ICCI	ıc	-



#### D3506-1/-3 DOUBLER

MATERIAL:

6061-T6/T651 ALUMINUM PER QQ-A-250/11 (0.100 THICK)

(REF DART MATERIAL SPEC M6061T6S.100)

2) FINISH:

CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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# **Dart Aerospace Ltd**

DATE   STEP   PROCEDURE CHANGE   By   Date   Qty   ch	oproval nief Eng / rod Mgr Approval QC Inspector
	1
	2.5
Part No: PAR #: Fault Category: NCR: Yes No DQA:	Date:
Resolution: Disposition: QA: N/C Closed:	Date:
NCR: WORK ORDER NON-CONFORMANCE (NCR)	
DATE STED Description of NC Corrective Action Section B Verification Approximation	pproval Approval
	chief Eng QC Inspector
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